

Work Order ID 159044

Tuesday, April 04, 2017 4:48:26 PM

159044

Page 1

Item ID: D3393-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Battery Lock

Start Date: 4/8/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 4/13/2017 Req'd Qty: 3.00

3

Customer:

Reference: SCHEDULED

Approvals:

Process Plan:

DAS

Date: APR 05 2017

Tooling:

Date:

QC:

21
9-89

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3393	Rev A ✓

100

0.00

100

Small Fab

Small Fab

Memo

0.66

Small Fab

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

Identify as D3369-53-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten

DAS
30
9-89

3

MAY 01 2017

110

0.00

110

Large Fab

Large Fab

Memo

0.87

Large Fab

Tack Weld lock shaft to flat cam of a Max 1/8" Long QtyPart Number
Description Batch A/RN/A SS Rod M/36585

3 12 17-5-3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____					

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NS1

NS?

Customer:

3

3

NR1

NR2

Date:

**Insp.
Stamp**

MAY 08 2017

0.03

MAY 08 2017

17/5/98

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 159044

159044

Parent Item: D3393-041

D3393-041

Parent Item Name: Battery Lock

Start Date: 4/8/2017

Required Date: 4/13/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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5/16WC *5/16WC* Washer		Purchased	No			100	Each	777.0000	2	6			
										**	FF	APR 06 2017	

Location	Loc Qty	Loc Code
ST583	600	
<u>m137100</u>	600	
WA001	177	
<u>m136525</u>	177	

9567K21 *9567K21* Polyethylene Cap		Purchased	No			100	Each	21.0000	2	6			
										**	FF	APR 06 2017	

Location	Loc Qty	Loc Code
ST588	21	
<u>m129254</u>	21	

D2728-7 *D2728-7* Dart Logo Label		Manufactured	Yes			100	Each	0.0000	1	3			
										**	3	FF	APR 06 2017

D3369-5 *D3369-5* Spacer		Manufactured	No			100	Each	1.0000	1	3			
										**	3	FF	APR 06 2017

Location	Loc Qty	Loc Code
ST031	1	
<u>B 133594</u>	1	
<u>154002</u>	1	

22
1

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Work Order ID: 159044

159044

Parent Item: D3393-041

D3393-041

Parent Item Name: Battery Lock

Start Date: 4/8/2017

Required Date: 4/13/2017

Start Qty: 3.00

Required Qty: 3.00

D3373-1

Manufactured No

100

Each

16.0000

1

3

D3373-1

Cam Lock

FF

APR 06 2017

Location

Loc Qty

Loc Code

GA

11

139798

1

147075

10

ST032

5

74862

5

3

D3393-1

Manufactured No

100

Each

6.0000

1

3

D3393-1

Battery Lock Casing

FF

APR 06 2017

Location

Loc Qty

Loc Code

ST501

6

147272

6

3

D3393-3

Manufactured No

140

Each

2.0000

1

3

D3393-3

Cam Lock Shaft

FF

APR 06 2017

Location

Loc Qty

Loc Code

ST033

2

144011

2

B 158938 ①

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
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Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
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Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
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